

Work Order ID **56910**

March 12, 2010 1:28:01 PM



Page 1

Item ID: D3705-3

Accept



Setup Start



Revision ID:

Item Name: COVER PLATE

Stop



Start Date: 12/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date: *10-3-15*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID:

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr										
D3705	Rev C										
100		0.00									
	FLOW WATER JET										
Waterjet	Memo	0.00									
FLOW CNC Waterjet	1-Cut as per Dwg D3705 <input type="checkbox"/> Dwg Rev: <i>C</i> <input type="checkbox"/> Prog Rev: <i>C</i>										
<i>6061 . 080</i>	<input type="checkbox"/> ***grain direction along 26.57"*** <input type="checkbox"/> 2- Deburr if necessary										
110	QC2- Inspect parts off machine FAI/FAIB	0.00									
	Memo	0.00									
QC											
Quality Control											
120	QC8- Inspect parts - second check	0.00									
	Memo	0.00									
QC											
Quality Control											

8 w/03/17

(6)

(B) 10-3-16

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56910

March 12, 2010 1:28:01 PM



Page 2

Item ID: D3705-3

Accept



Setup Start



Revision ID:

Item Name: COVER PLATE

Stop



Start Date: 12/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

1

1

1

1

1

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1

1

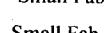
1

1

1

1

Small Fab



Small Fab



Small Fab



140



QC5- Inspect part completeness to step on W/O

0.00

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

QC



Quality Control

150



Identify as per dwg & Stock Location: ST 175

0.00

1

1

1

1

1

1

1

1

1

1

1

1

Packaging



Packaging

SD 10/04/22

L> EF 10/03/18

S 10/04/03

(C)

(X6)

(6X)

M-1 10/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 56910

March 12, 2010 1:28:01 PM



Page 3

Item ID: D3705-3

Accept



Setup Start



Revision ID:

Item Name: COVER PLATE

Stop



Start Date: 12/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
Stamp

10/04/2010

B810-4-27

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 1:28:05 PM

Page 1

Work Order ID: 56910



Parent Item: D3705-3



Parent Item Name: COVER PLATE

Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A 08-01-30 new issue EC verified by:DD
IPP Rev:B 09-01-09 rev.c as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080				No			sf	111.7997	4.4400			



6061T6S.080 Sheet

BB 10-3-16

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	111.79967	
110630	35.0136	
112141	0.86727	
112763	0.19	
113438	75.7288	113438

(6)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<u>56910</u>
Description: Cover Plate	Part Number:	D3705-3
Inspection Dwg: D3705 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-3-16	Date: 10/03/17	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

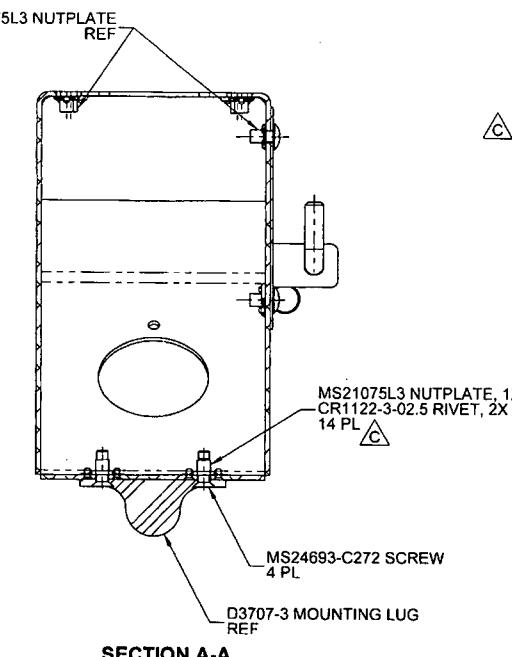
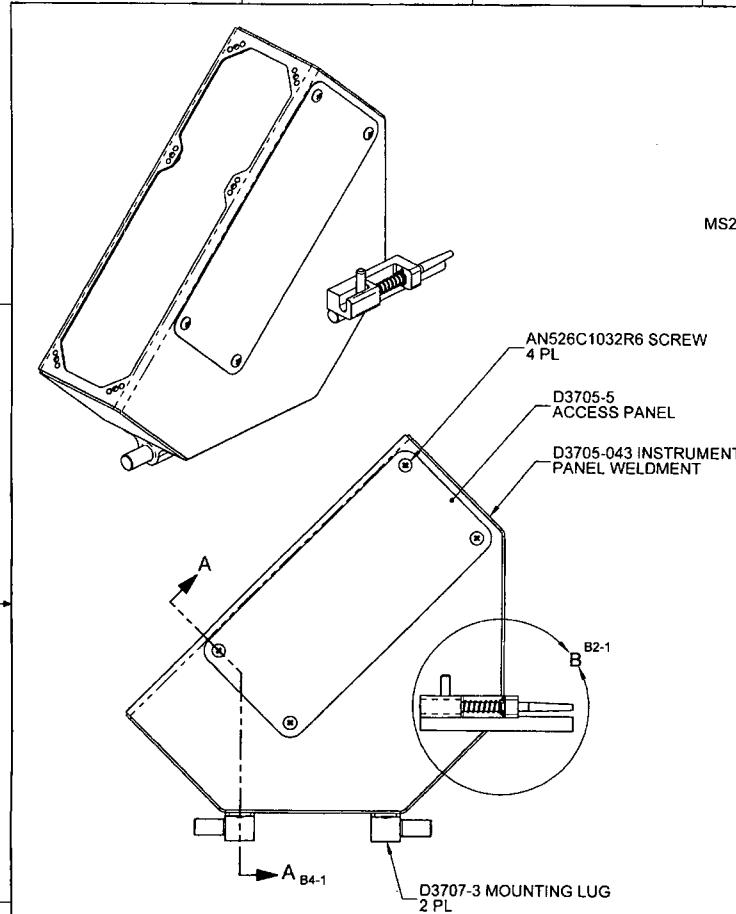
SUBJECT TO AMENDMENT

WITHOUT NOTICE

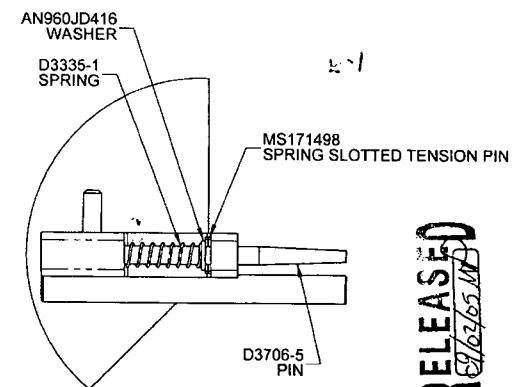
WORK ORDER

NO. 5CA10
010-3-15

8 7 6 5 4 3 2 1



ITEM	QTY	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET

RELEASED
RE 07/02/2014DETAIL B
SCALE 2X B6-1

C	ADDED D3705-7/9-11 (SHEET 6): REMOVED MS35589-156 GROMMET, 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3); Ø1.90 WAS 1.50 (ZN D5-4). ADDED Ø0.204 HOLE (ZN D5-3). CR1122-3-02.5 WAS MS20426AD3-3. REASON: GIVE MORE FLEXIBILITY TO FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156, QTY 14. MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 10. MS171498 WAS TP-2; AN526C1032R6 WAS MS21075L3-09 & AN960JD416 (ZN D5-1). REDESIGNED D3705-1 FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT.	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1a</i>		
DRAWN	<i>b</i>		
CHECKED	<i>AS</i>		
MFG. APPR.	<i>RS</i>		
APPROVED	<i>AS</i>		
DE APPR.	<i>AS</i>		
DATE	08.11.20		
		DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. C
		D3705	
		TITLE	SCALE
		INSTRUMENT PANEL ASS'Y	NTS
		Copyright © 2008 by DART Aerospace Ltd. This document is private and confidential and is supplied on the express condition that it is not to be used for any other purpose or disclosed to any other person without written permission from DART Aerospace Ltd.	

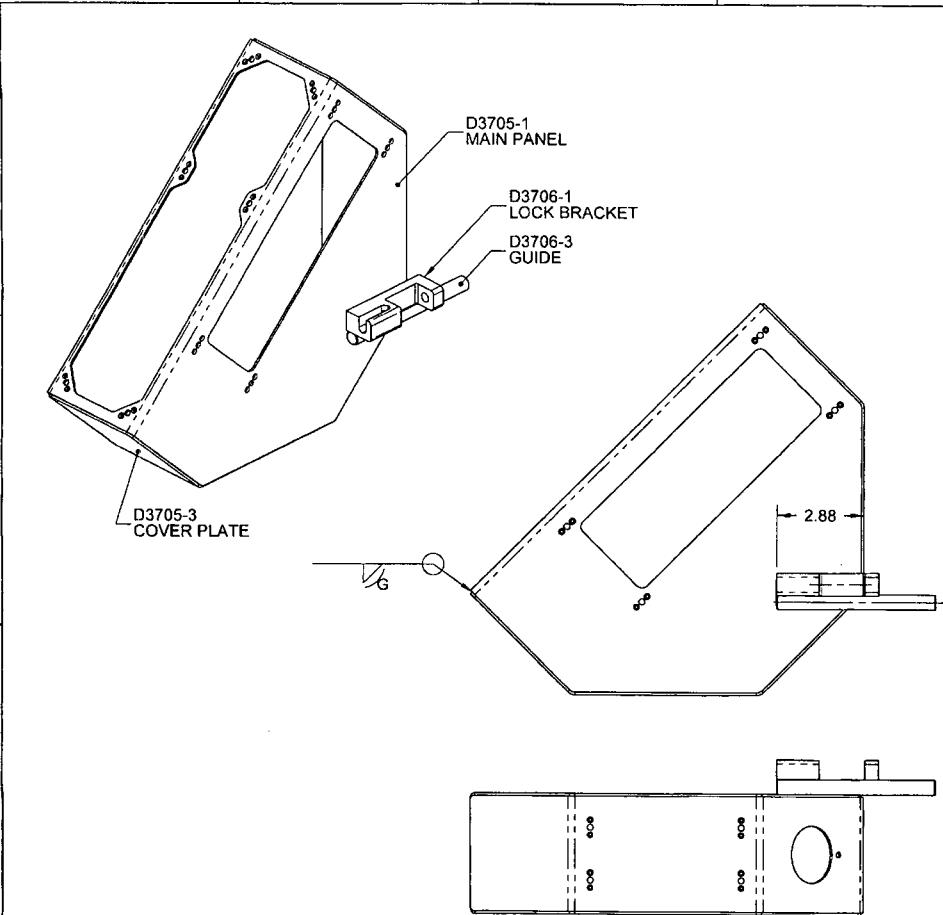
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3705-043 INSTRUMENT PANEL WELDMENT

ITEM	QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3705 REV. C	
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 6	
APPROVED	<i>[Signature]</i>	TITLE INSTRUMENT PANEL ASS'Y NTS	
DE APPR.	<i>[Signature]</i>	SCALE	
DATE	08.11.20		

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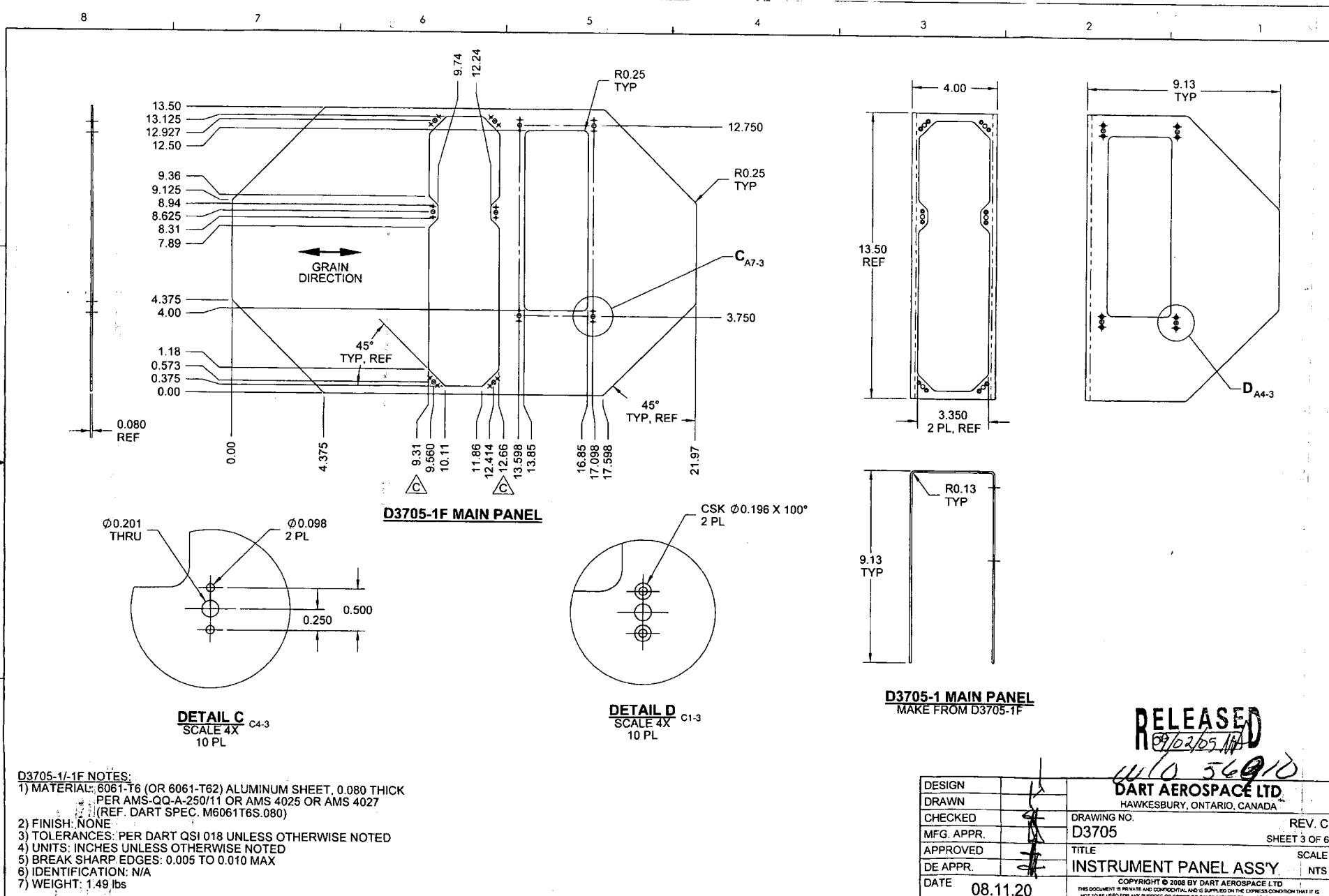
RELEASED
08/22/05 MHD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

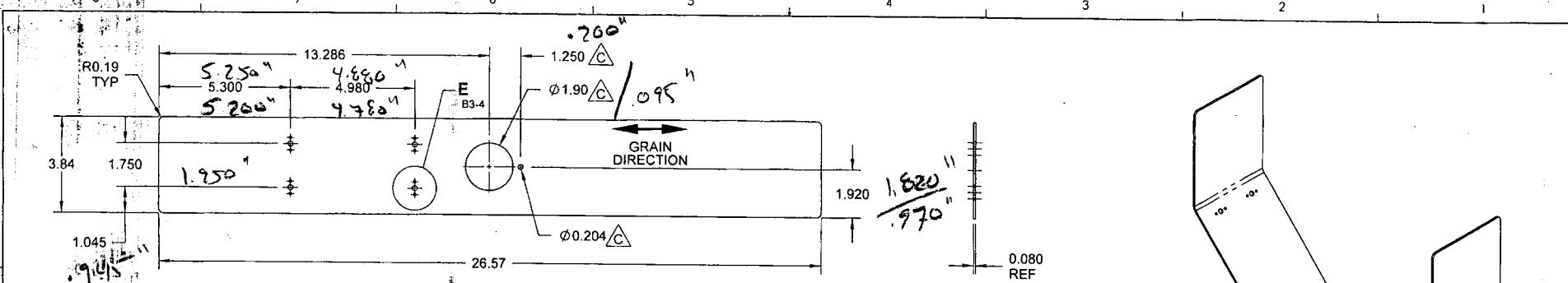


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

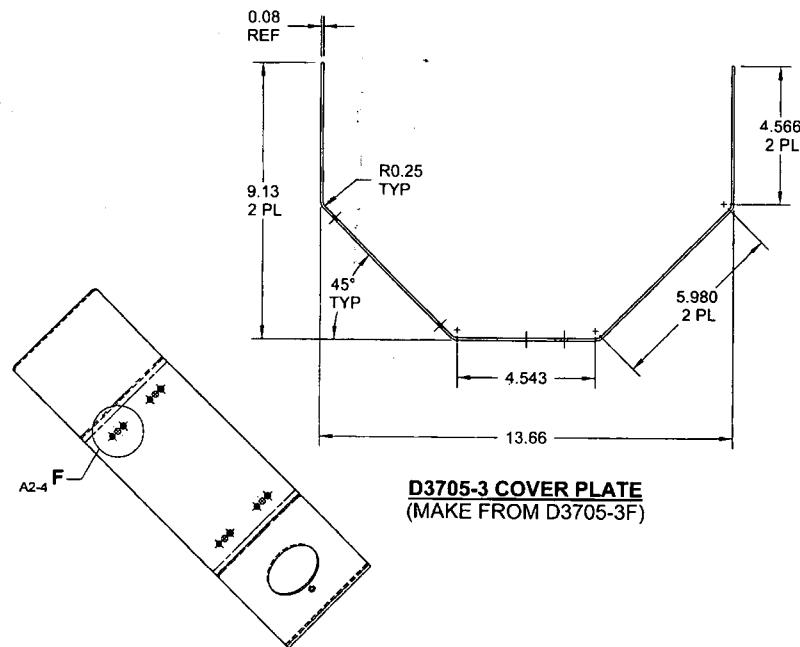
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

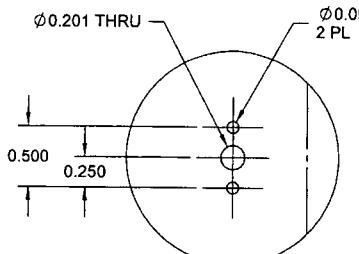
NOTE: Date & initial all entries



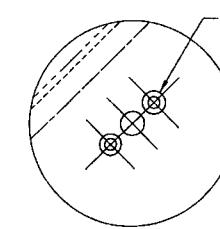
D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



DETAIL E 06-4
SCALE 4X
4 PL



DETAIL F B8-4
SCALE 4X
4 PL

RELEASED
07/21/05 AM

D3705-3/3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. 'DART SPEC. M6061T6S.080')
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK/SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.77 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3705
MFG. APPR.		REV. C
APPROVED		SHEET 4 OF 6
DE APPR.		TITLE
DATE	08.11.20	SCALE
		INSTRUMENT PANEL ASSY
		NTS

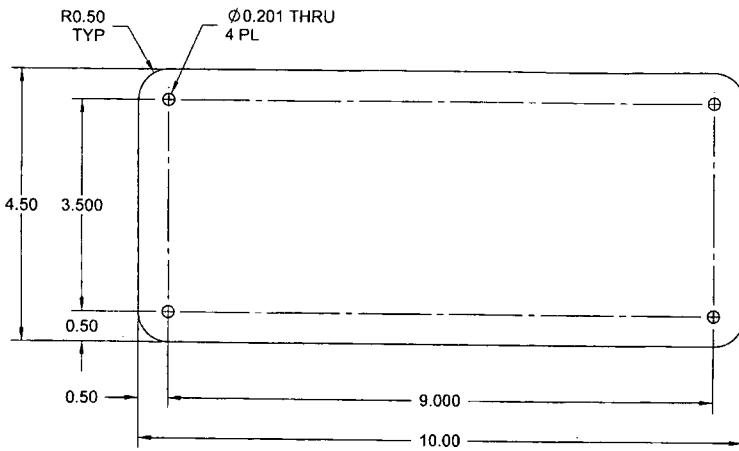
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3705-5 ACCESS PANEL

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

DESIGN	<i>1b</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>1b</i>		
CHECKED	<i>1b</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>1b</i>	D3705	SHEET 5 OF 6
APPROVED	<i>1b</i>	TITLE	
DE APPR.	<i>1b</i>	SCALE	
DATE 08.11.20		NTS	

INSTRUMENT PANEL ASS'Y

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w/o 560910

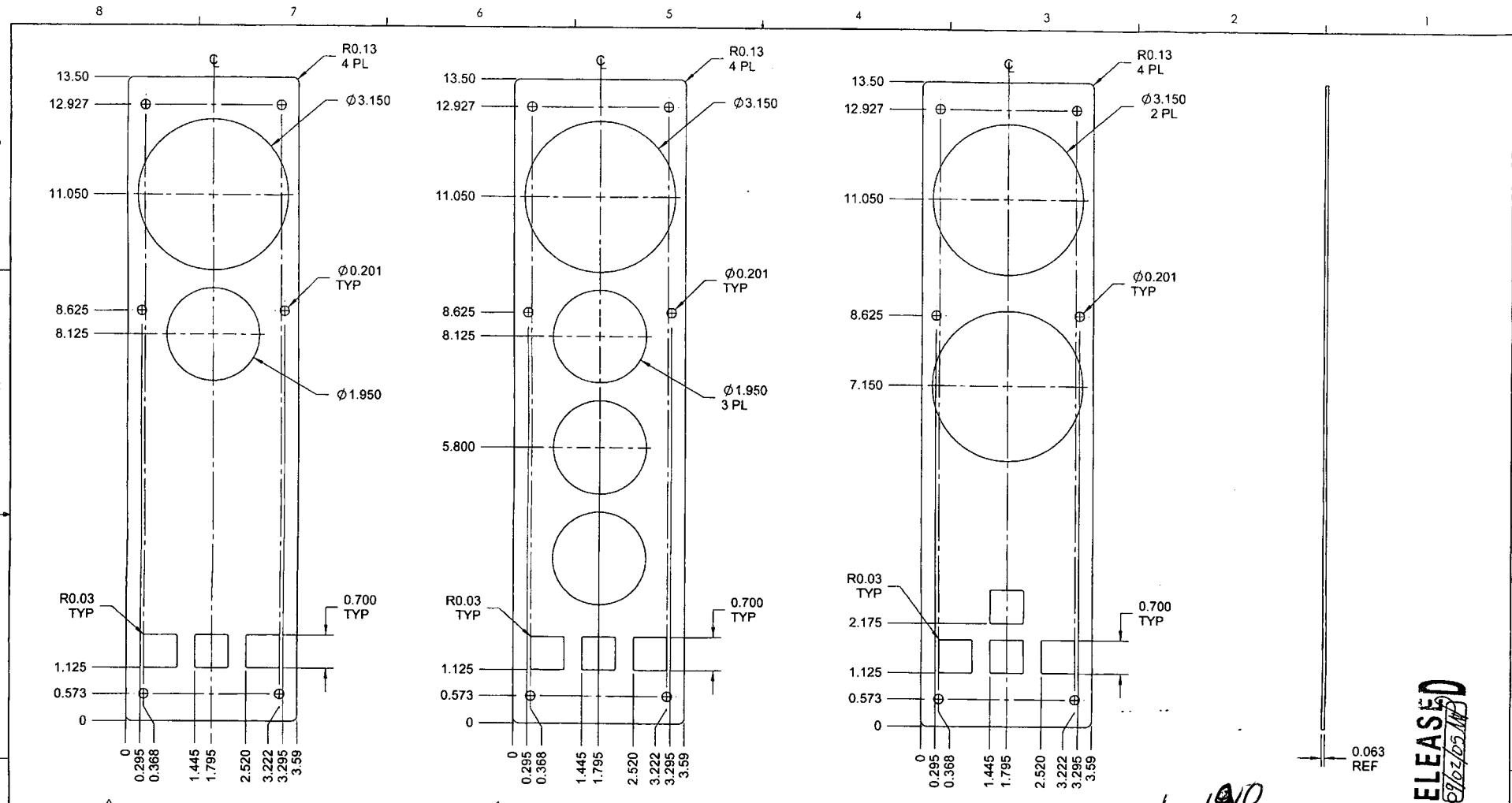
RELEASED
9/10/05 MWD

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D3705-7/9-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-X" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

DESIGN	<i>✓</i>	DART AEROSPACE LTD
DRAWN	<i>✓</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>✓</i>	DRAWING NO. D3705 REV. C
MFG. APPR.	<i>✓</i>	SHEET 6 OF 6
APPROVED	<i>✓</i>	TITLE
DE APPR.	<i>✓</i>	SCALE
DATE	08.11.20	INSTRUMENT PANEL ASS'Y NTS

W/0 35/40

RELEASED
09/02/2014

SIDE VIEW
TYP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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